

Work Order ID 60178

Monday, June 28, 2010 1:30:24 PM



Page 1

Item ID: D3836-041

Accept



Setup

Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/28/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: PL

Date: 10-07-08 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3836	Rev A

100



Large Fab

0.00

②

PL 10-07-08

Large Fab

Memo

0.00

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open
to finish size as per dwg D3836

SAD 10-07-07

5- weld D2327-3 spacer bushing as per dwg D3836
A/R ER316 S.S. Rod Batch: 111679

6- grind weld flush where indicated on dwg

130



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

②

PL 10-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60178

Monday, June 28, 2010 1:30:24 PM



Page 2

Item ID: D3836-041**Accept****Revision ID:****Item Name:** Rib Assembly (Basket Lid, LH)**Start Date:** 6/28/2010 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 7/2/2010 **Req'd Qty:** 2.00**Customer:****Reference:**

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Setup	Start	
	Stop	
Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	510107108						
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>B/C</u> Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MF
10-7-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 28, 2010 1:30:28 PM

Page 1 /1

Work Order ID: 60178



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/28/2010

Required Date: 7/2/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3 Manufactured No 100 Each 11.0000 1 2



Spacer Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	11	
----	----	--

58406	1	
-------	---	--

58974	10	
-------	----	--

GL 10-07-08
359980 → (2)

M304TS0.750W.065 Purchased No 100 f 617.4786 1.7808 3.749053



304 SQ Tube .75x.75x.065W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

MAT	1.4628	
-----	--------	--

112398	0	
--------	---	--

114482	1.4628	
--------	--------	--

WA	616.015785	
----	------------	--

114520	616.015785	
--------	------------	--

SAD 10-07-08

3.7491

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

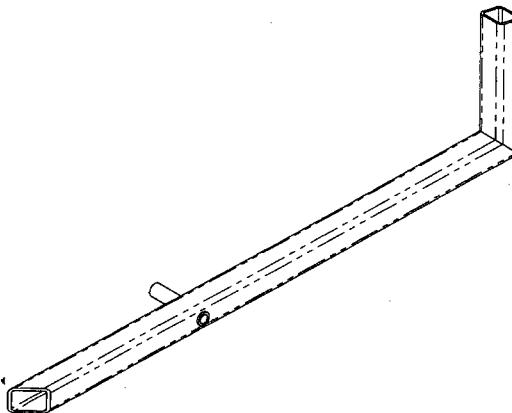
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

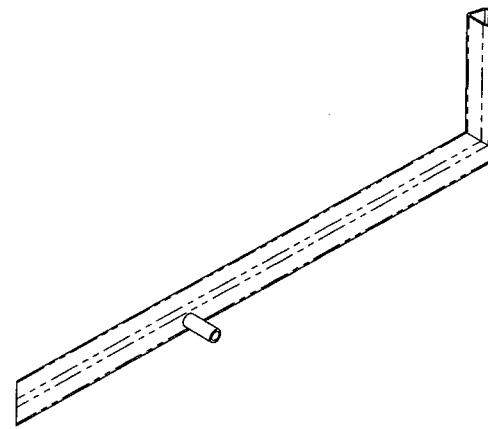
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

D

C

B

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. Co178
pd106-28

RELEASED
08/11/08 MJP

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<u>A-3</u>		
MFG. APPR.	<u>M</u>		
APPROVED	<u>M</u>		
DE APPR.	<u>M</u>		
DATE	08.09.24	SCALE	NTS
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. A
		D3836	SHEET 1 OF 3
		TITLE	
		RIB ASSY (BASKET LID)	

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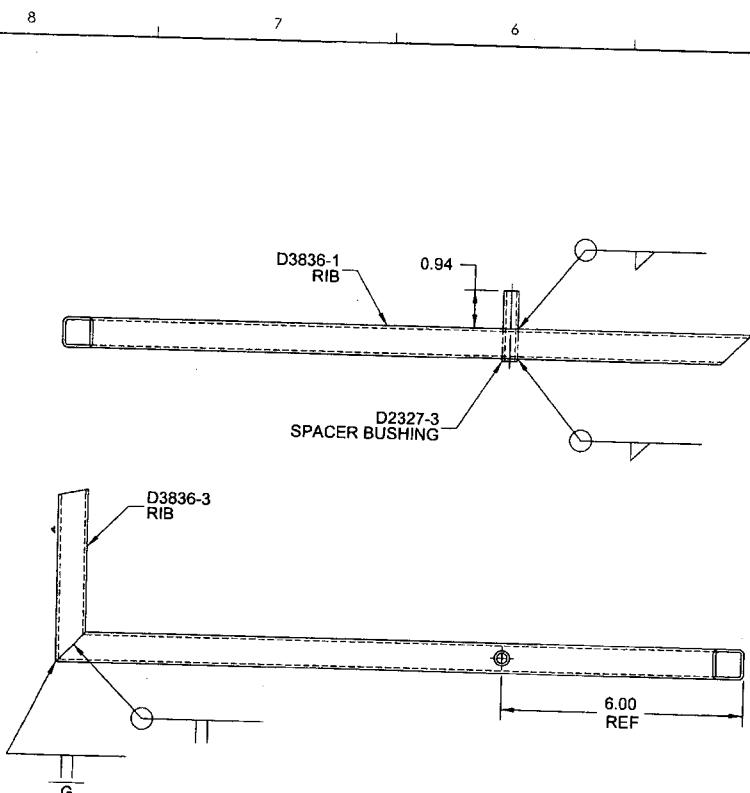
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

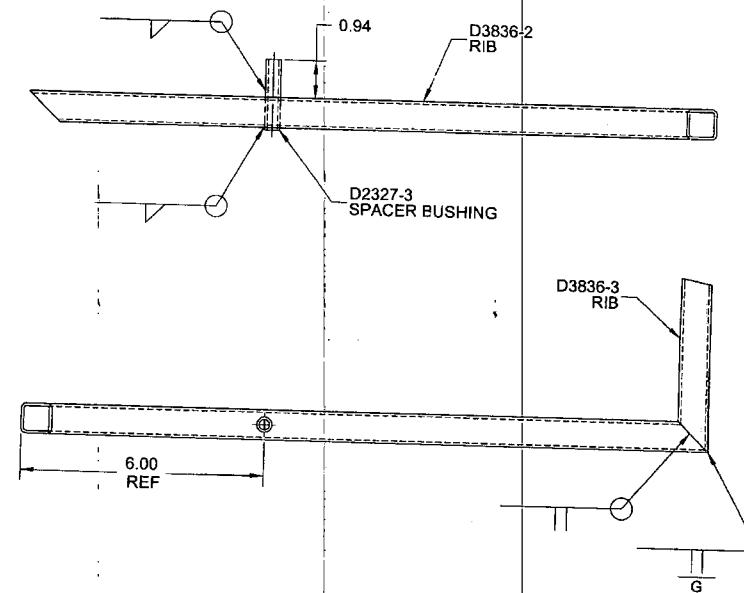
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

who 60178

RELEASED
08/11/18 MHD

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	REV. A
MFG. APPR.	<i>AS</i>	SHEET 2 OF 3
APPROVED	<i>AS</i>	
DE APPR.	<i>AS</i>	NTS
DATE	08.09.24	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

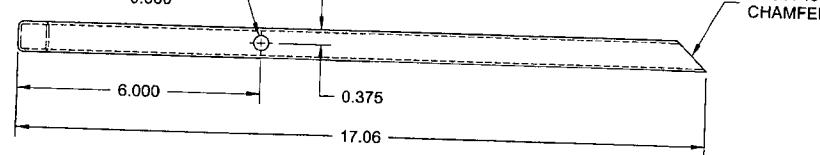
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NOTE: Date & initial all entries

0.75 X 45°
CHAMFER



∅0.375^{+0.020}
-0.000 THRU

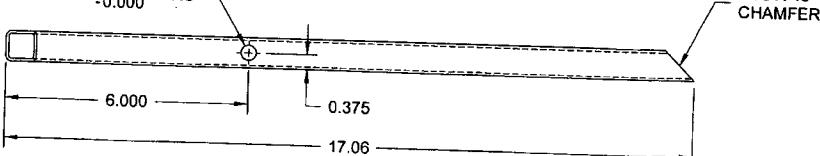


D3836-1 RIB

0.75 X 45°
CHAMFER



∅0.375^{+0.020}
-0.000 THRU



D3836-2 RIB

WLS 60178

A NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

8

7

6

5

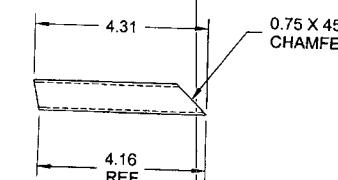
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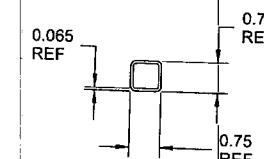
2

1

0.75 X 45°
CHAMFER



D3836-3 RIB



TYPICAL SECTION
VIEW

RELEASED
08/11/08/10

DESIGN	<i>fb</i>	DART AEROSPACE LTD
DRAWN	<i>JAS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JAS</i>	DRAWING NO.
MFG. APPR.	<i>JAS</i>	REV. A
APPROVED	<i>JAS</i>	SHEET 3 OF 3
DE APPR.	<i>JAS</i>	TITLE
DATE	08.09.24	SCALE
		RIB ASSY (BASKET LID)
		NTS

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